

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER : _____							

Work Order ID 144839

April 26, 2016 9:16:54 AM

144839

Page 2

Item ID: 650.6316 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Swivel Fitting
Start Date: 4/26/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/13/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.12				6	0		16/05/06
Quality Control									
130	Identify as per dwg & Stock Location	0.00							
130									
Packaging	Memo	0.08				6			DAS 6 9-89
Packaging									MAY 09 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.04				ML5			MAY 10 2016
Quality Control									

ML5 MAY 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

April 26, 2016 9:16:59 AM

Page 1

Work Order ID: 144839

144839

Parent Item: 650.6316

650 6316

Parent Item Name: Swivel Fitting

Start Date: 4/26/2016

Required Date: 6/13/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 15.03.19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R1.000		Purchased			No		f	56.5000		0.56			

M174PH-H900R1 000

17-4SS H900 ROUND BAR 1.00

Location

Loc Qty

Loc Code

MAT031

56.5

m127334

16.5

m128314

40

1.0 ~~1.0~~

DAS

45

9-89

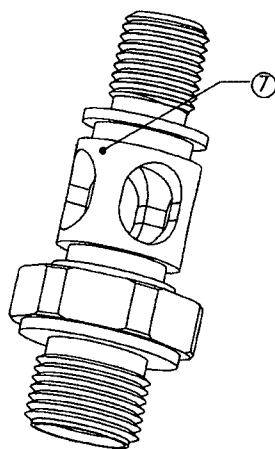
2016-5-4

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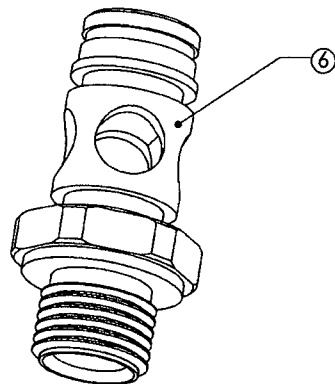
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
NC	INITIAL RELEASE	04-28-14	P. BRAVO
A	INCORPORATED ECN 04699	10-06-14	P. BRAVO
B	INCORPORATED ECN 04874	03-11-15	P. BRAVO
C	INCORPORATED ECN 04900	03-12-15	P. BRAVO
D	INCORPORATED ECN 04912	04-01-15	P. BRAVO
E	INCORPORATED ECN 04942 AND 04989	06-30-15	P. BRAVO
F	INCORPORATED ECN 05081	08-12-15	P. BRAVO
G	INCORPORATED ECN 05089	08-14-15	P. BRAVO

NOTES:

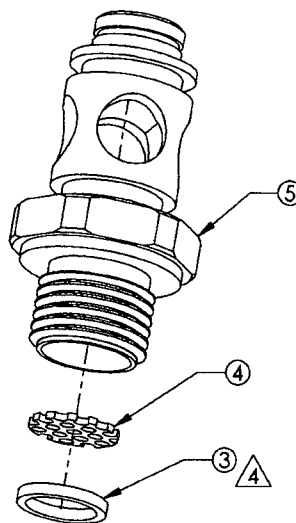
1. DEBURR AND BREAK ALL SHARP EDGES.
2. MATERIAL: 17-4PH H1150 STAINLESS STEEL.
3. IDENTIFY IAW MP-120.
4. SECURE F/N 3 BY STAKING EDGE ON F/N 1 OR 2 EVERY 90°.
5. MATERIAL: PERFORATED 304 SS SHEET, VENDOR: MCMaster-CARR. VENDOR P/N: 9358T281.
6. FINISH: IAW MPP-172 ELECTROPOLISH IAW SECTION 7.1 AND PASSIVATE IAW SECTION 6.1.
7. TOLERANCES DO NOT APPLY AFTER STAKING (REFER TO FLAGNOTE 4).
8. MATERIAL: 17-4PH H900 STAINLESS STEEL



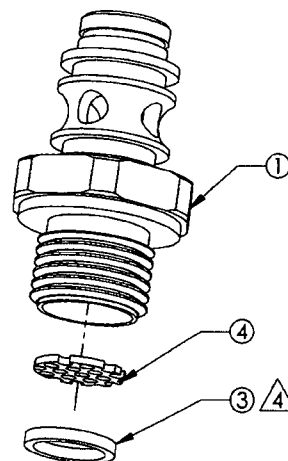
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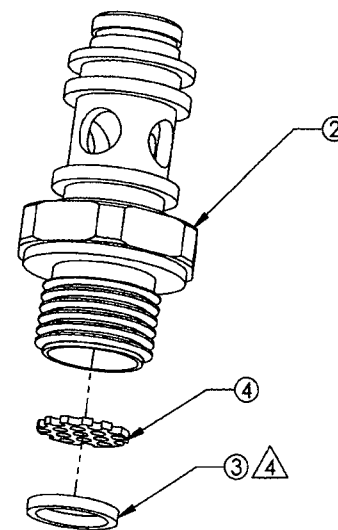
650.6315



650.6303



650.6301



650.6302

			7	650.6316	SWIVEL FITTING	△	△
			6	650.6315	SWIVEL FITTING	△	△
1			5	650.6314	SWIVEL FITTING	△	△
1	1	1	4	650.6313	SCREEN	△	
1	1	1	3	650.6312	SCREEN RETAINER	△	△
	1		2	650.6311	SWIVEL FITTING	△	△
		1	1	650.6310	SWIVEL FITTING	△	△
X				650.6303	SWIVEL FITTING ASSY		
	X			650.6302	SWIVEL FITTING ASSY		
		X		650.6301	SWIVEL FITTING ASSY		
ASST	ASST	ASST	FIND #	PART #	DESCRIPTION	MATL	SPEC.

PARTS LIST			
QTY	ORIGINAL DATE (MM-DD-YY)	04-28-2014	
NEXT ASSY (S)	DRAWN BY	ICHECKER	
650.5300	IN CAP	P. BRAVO	
	DRAWING APPROVAL		
	DATE	04-28-2014	
	CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS .0100 2 PLACE DECIMALS .0050 ANGLES ± .5°			
SIZE	CAGE CODE	DWG. NO.	REV.
B	07MA26	650.6300	G
SCALE		SHEET 1 OF 12	

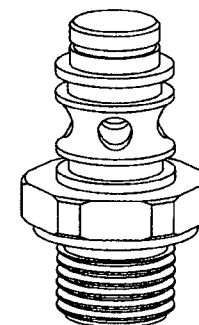
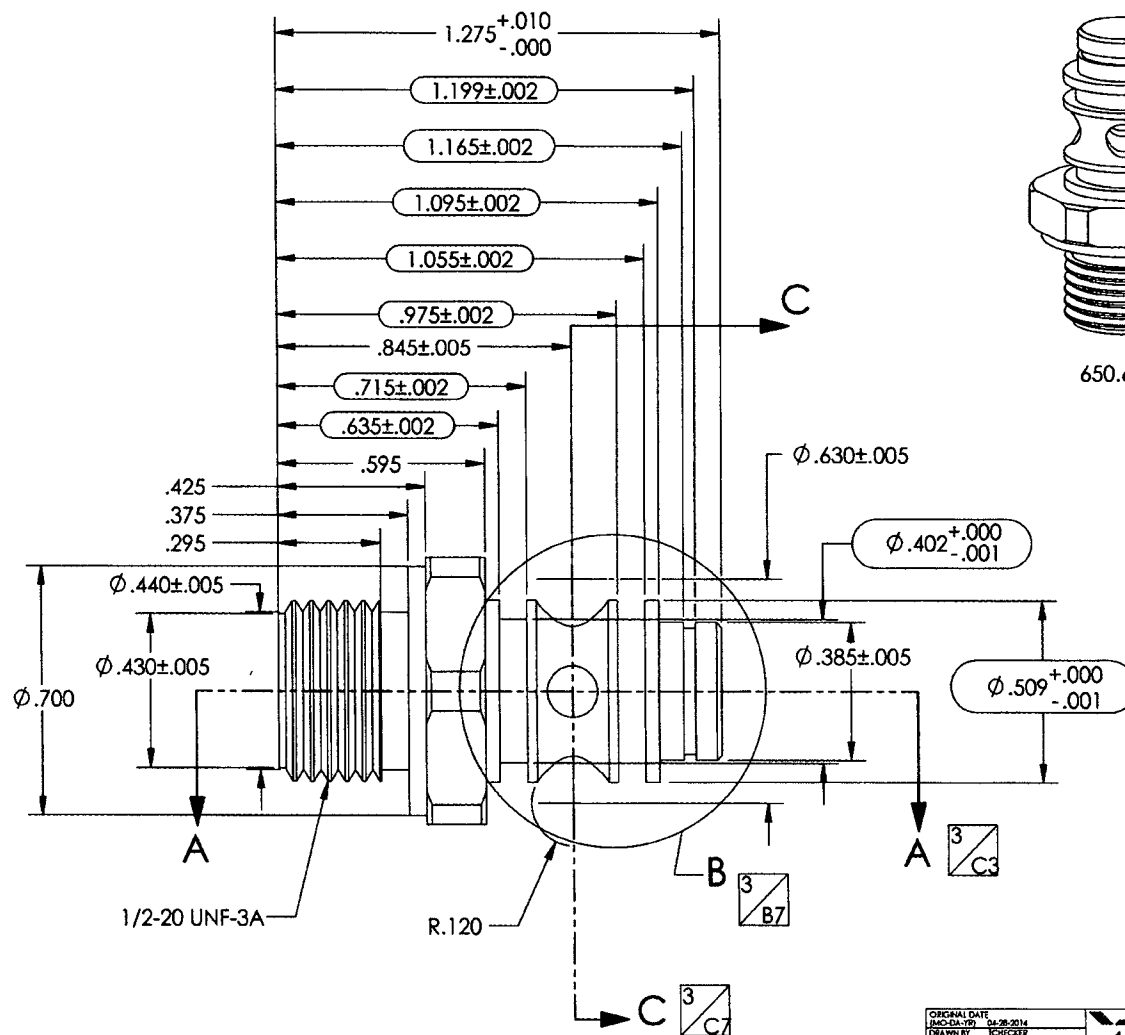
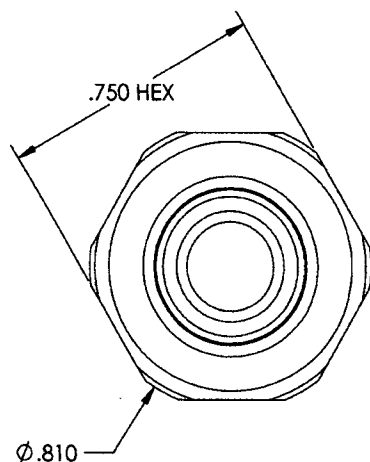
DART 3030 ENTERPRISE CT., SUITE A
VISTA, CA, 92081
(760)-724-5300

APICAL INDUSTRIES, INC.
DBA DART AEROSPACE

SWIVEL FITTING

20160427
SA144839

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650.6310

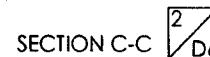
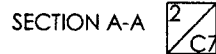
ORIGINAL DATE
JMO-DA-179 04-28-2014
DRAWN BY: CHICKSEY
H. CAP P. BRAVO
DRAWING APPROVAL
P. BRAVO
04/28/2014
CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.010
3 PLACE DECIMALS ±.005
ANGLES ±.5°

DART 3030 ENTERPRISE CT., SUITE A
AEROSPACE VISTA, CA 92081
APICAL INDUSTRIES, INC. (DBA DART AEROSPACE)
(760)-724-5300

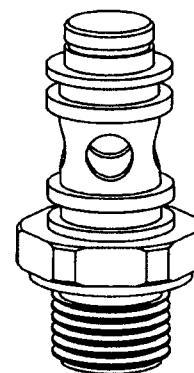
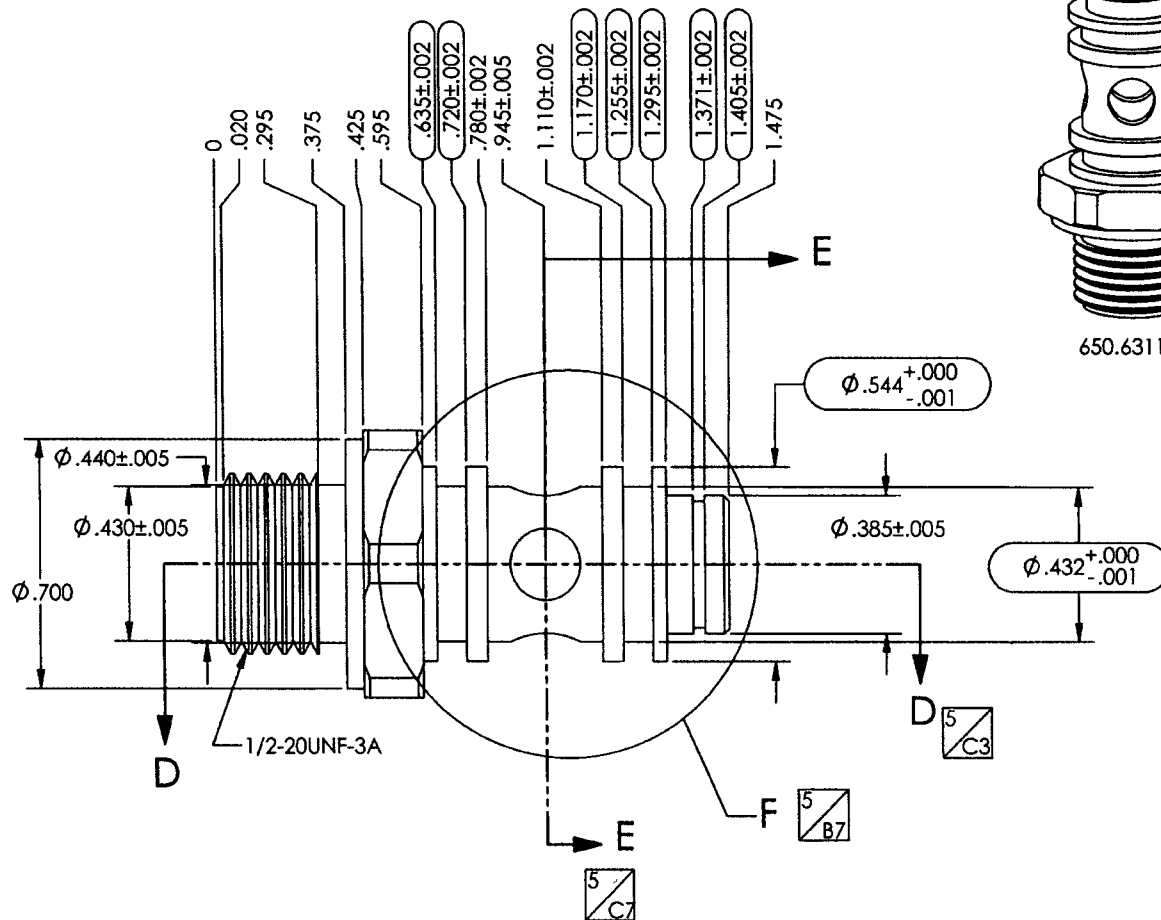
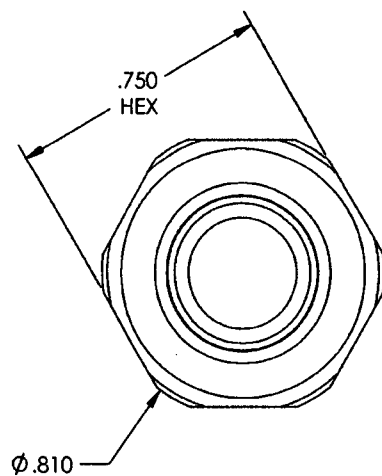
SWIVEL FITTING

REV.	G
DWG. NO.	650.6300
CAGE CODE	07M26
SCALE	NONE
SHEET	2 OF 12



ORIGINAL DATE: 04-28-2014	DART AEROSPACE APICAL INDUSTRIES INC. 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300 SWIVEL FITTING			
DRAWN BY: CHENGBER				
IN: CAP				
DESIGN APPROVAL: B. BAU				
DATE: 04-28-2014				
CONTACT: FNO				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE TO 3 PLACES 2 PLACES DECIMALS: 0.010 3 PLACES DECIMALS: 0.005 ANGLES: 1/2°				
SEE	CAGE CODE	QWG. NO.	REV.	
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SCALE: NONE		SHEET 3 OF 12		

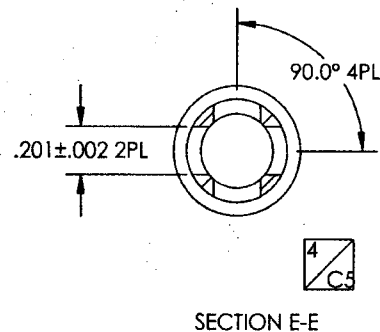
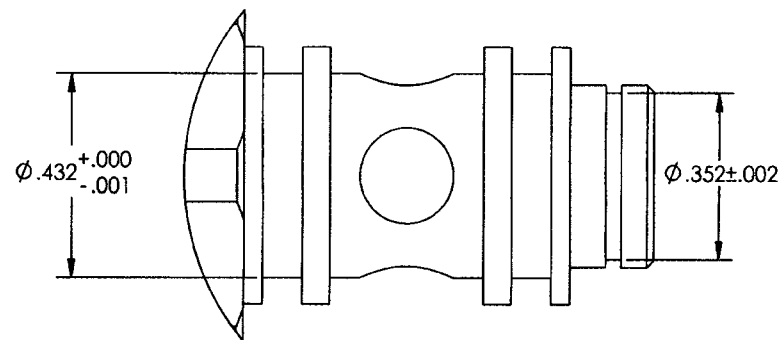
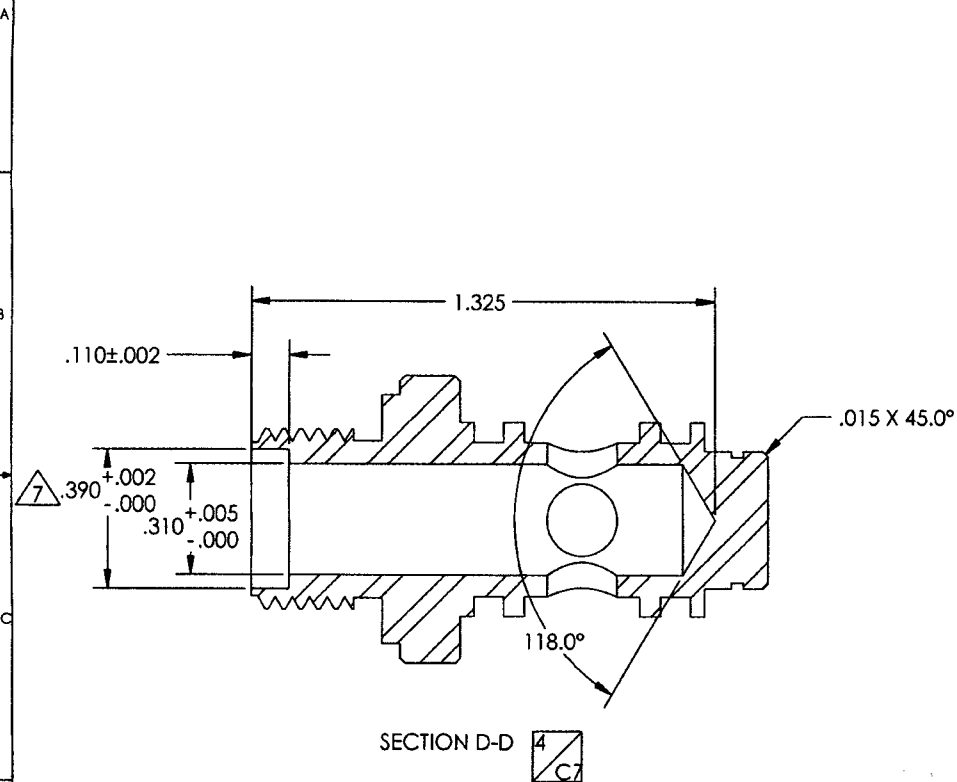
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650.6311

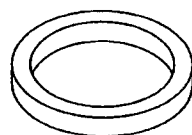
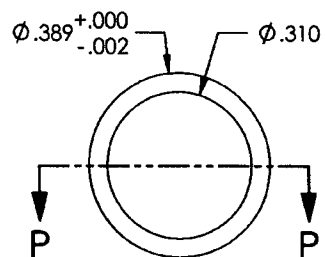
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DRAWN BY N. CAP	P. BRAVO		
DRAWING APPROVAL P. BRAVO			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±0.10 3 PLACE DECIMALS ±0.05 ANGLES ±5°		SEE B	DWG. NO. 07MZ6 650.6300 SCALE NONE
		REV. G	SHEET 4 OF 12

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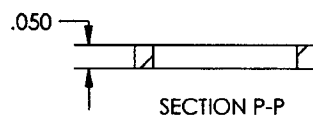


ORIGINAL DATE (MCO-DA-101) 04-28-2014		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760) 724-5300 AEROSPACE APICAL INDUSTRIES, INC. (DBA DART AEROSPACE)	
DRAWN BY N. CAP P. BRAVO			
DRAWING APPROVAL P. BRAVO 04-28-2014		SWIVEL FITTING	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV. G	
SHEET 3 OF 12		SCALE NONE	

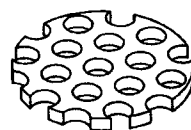
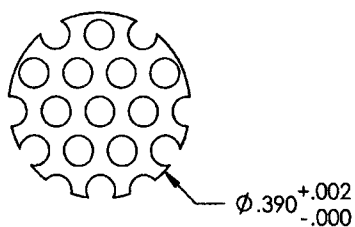
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650.6312



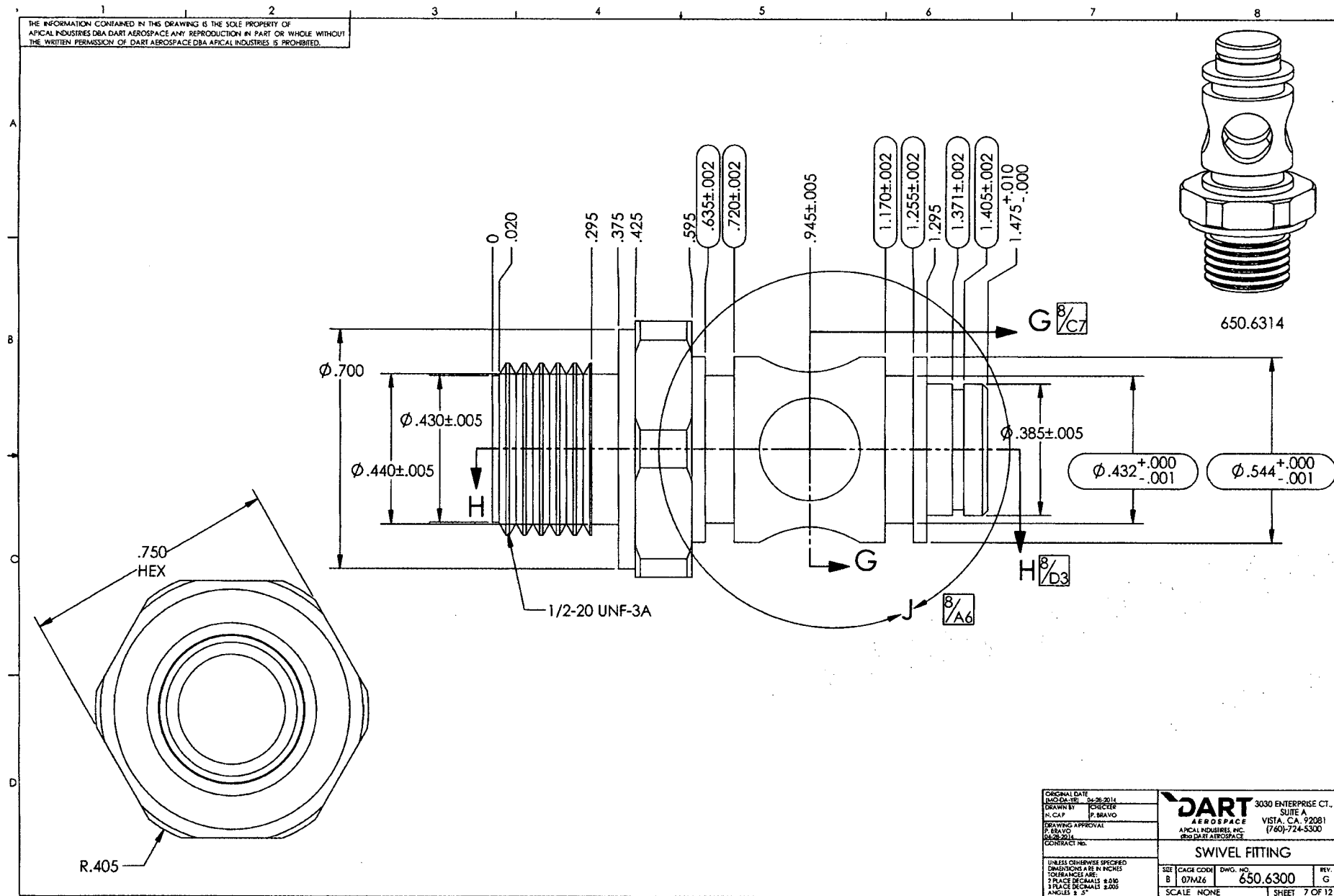
SECTION P-P



650.6313

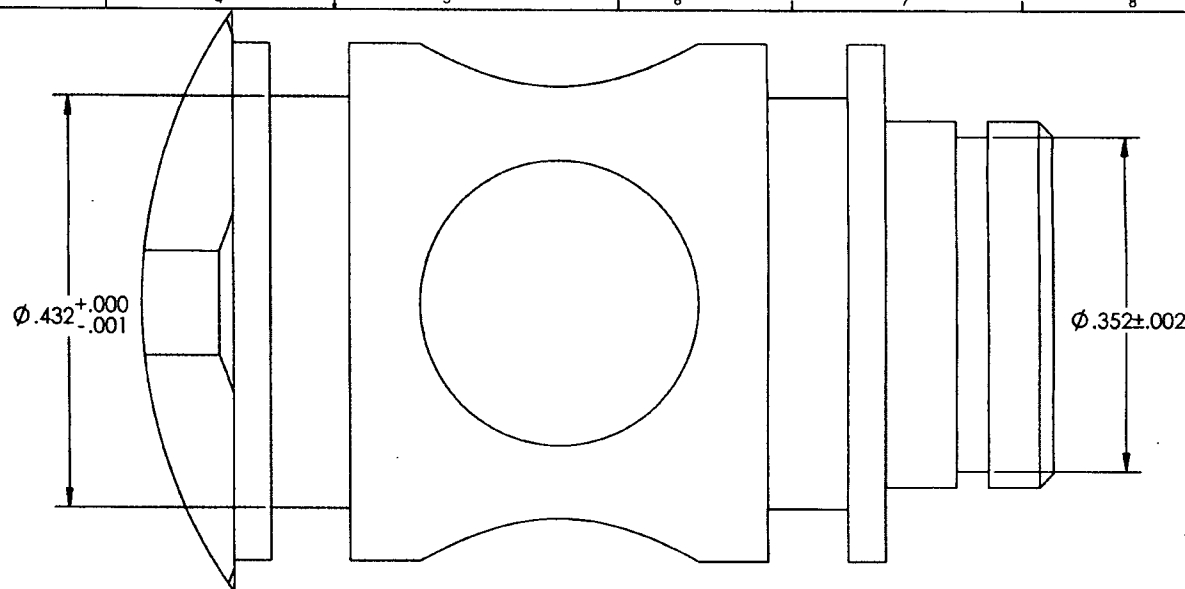
ORIGINAL DATE APICAL INDUSTRIES 04-28-2014		DART 3030 ENTERPRISE CT., AEROSPACE SUITE A VISTA, CA. 92081 (760)-724-5300 APICAL INDUSTRIES INC. dba DART AEROSPACE	
DRAWN BY: C. CRICER H. CAP: P. BRAVO			
DRAWING APPROVAL P. BRAVO 04/28/2014		CONTRACT NO.: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .010$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$	
SIZE	CAGE CODE	DWG. NO.	REV.
B	07MZ6	650.6300	G
SCALE: NONE		SHEET 6 OF 12	

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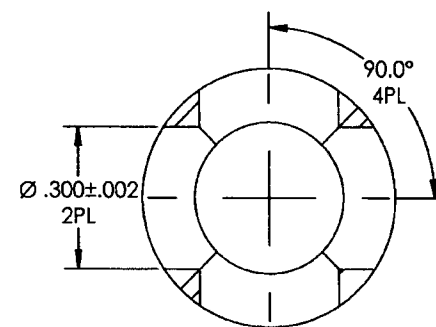


ORIGINAL DATE 04-28-2014		3030 ENTERPRISE CT., SUITE A	
DRAWN BY H. C.A.P.		VISTA, CA. 92081	
DRAWING APPROVAL P. BRAVO		(760) 724-5300	
CONTRACT NO.		SWIVEL FITTING	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .010$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B	REV. G
		CAGE CODE 07M26	DWG. NO. 650.6300
		SCALE NONE	SHEET 7 OF 12

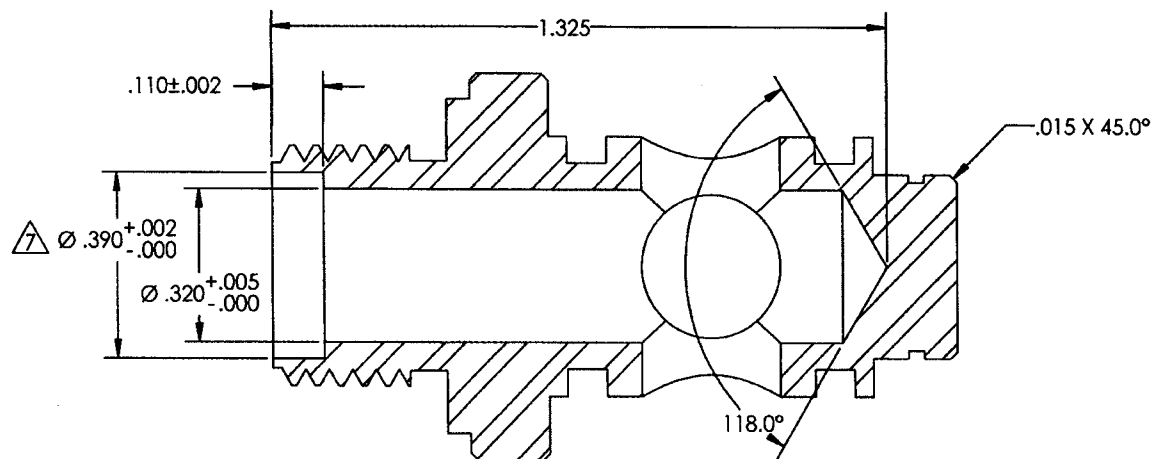
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THE WRITTEN PERMISSION OF DART AEROSPACE DBA APICAL INDUSTRIES IS PROHIBITED.



DETAIL J $\frac{7}{8}C5$



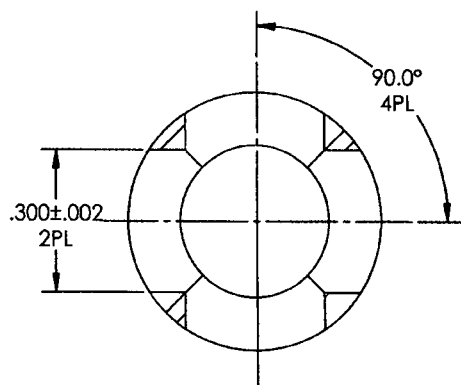
SECTION G-G $\frac{7}{8}C5$



SECTION H-H $\frac{7}{8}C5$

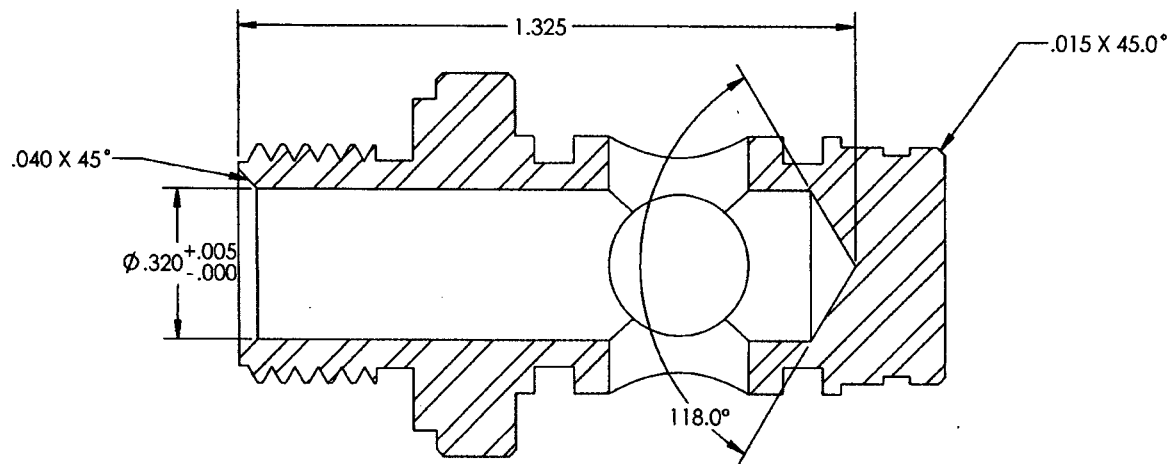
ORIGINAL DATE (MM-DD-YY) 04-26-2014		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY N. CAP	CHECKED P. BRAVO	DART AEROSPACE APICAL INDUSTRIES, INC. REG. DART AEROSPACE	
DRAWING APPROVAL P. BRAVO 04-26-2014		SWIVEL FITTING	
CONTRACT NO.		SIZE E	REV. G
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CAGE CODE 07M26	DWG. NO. 650.6300
		SCALE NONE	SHEET 8 OF 12

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SECTION L-L

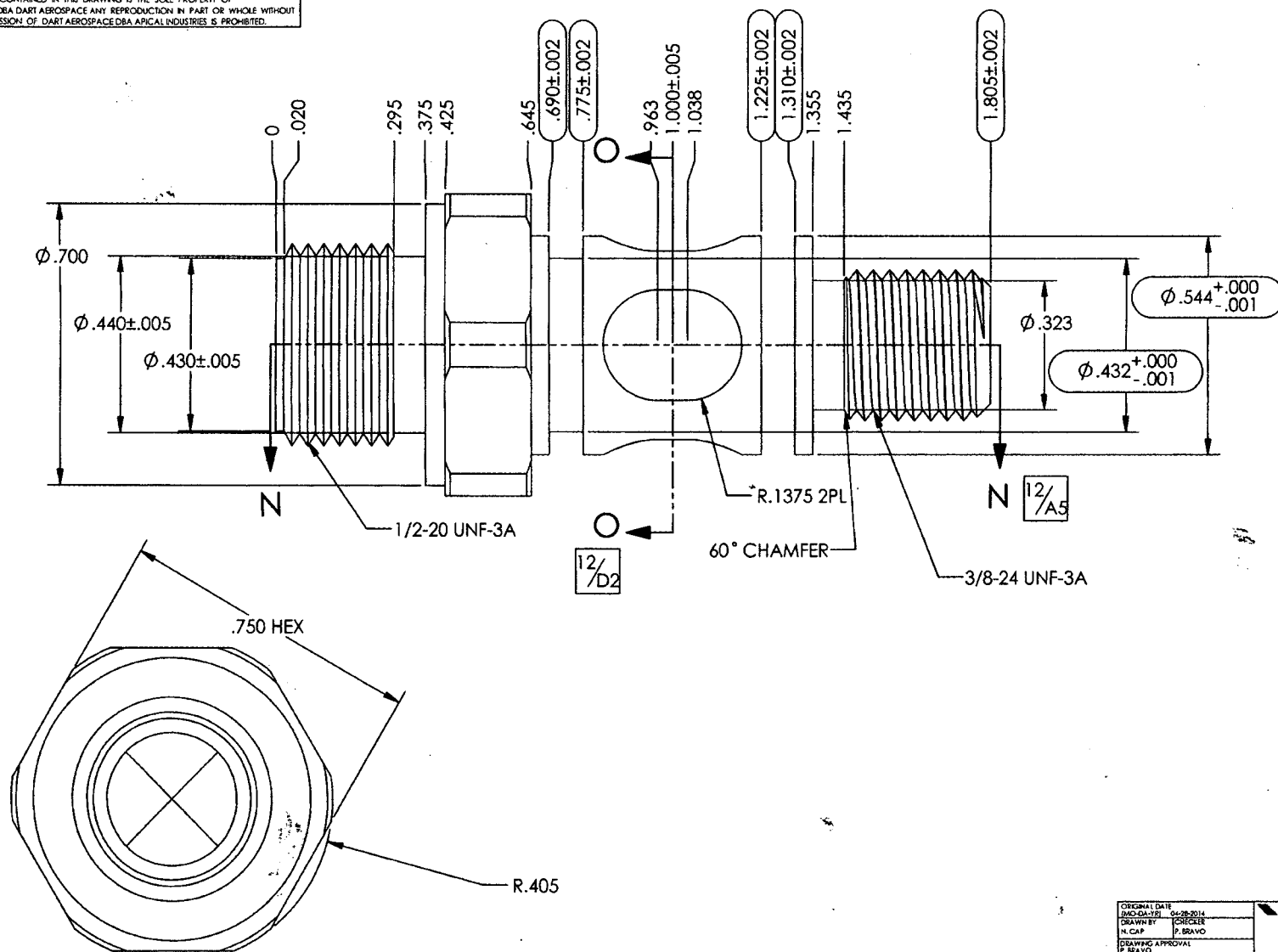
9/16
B4



SECTION K-K

9/16
B4

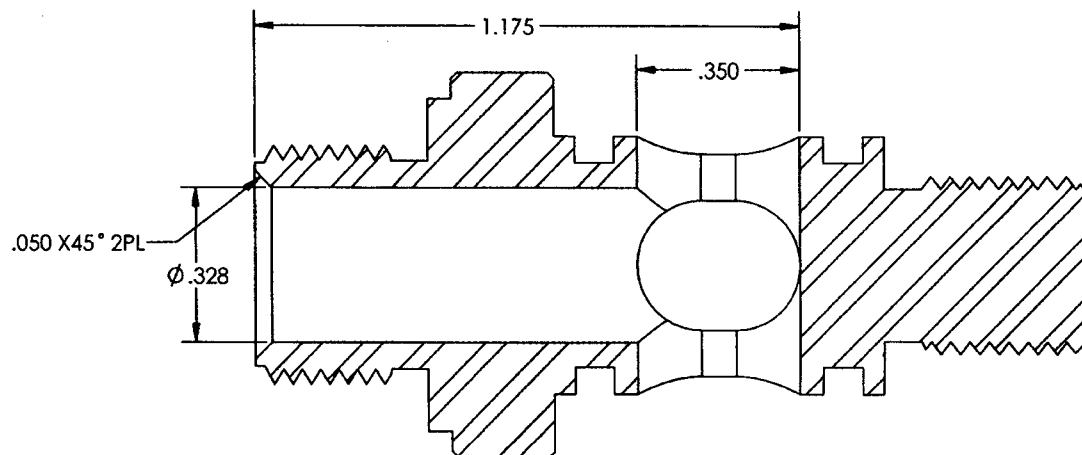
ORIGINAL DATE 04-28-2014		DART 3030 ENTERPRISE CT., SUITE A AEROSPACE VISTA, CA. 92081 APICAL INDUSTRIES, INC. (760)-724-5300 DBA DART AEROSPACE	
DRAWN BY N. CAP	CHECKED P. BRAVO		
DRAWING APPROVAL P. BRAVO 05-26-2014		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.010 ANGLES ±.5°		REV. B	REV. G
CAGE CODE 07M126		DWG. NO. 650.6300	SCALE NONE
SHEET 10 OF 12		SWIVEL FITTING	



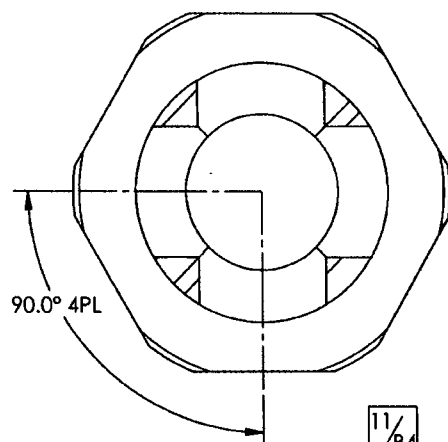
650.6316

ORIGINAL DATE AWO-CA-171	06-28-2014	 3030 ENTERPRISE CT. SUITE A VISTA, CA, 92081 (760)-724-5300	
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IN CHARGE	2. BRANNO		
DRAWING APPROVAL	3. BRANNO		
REV. BY	4. BRANNO	AEROSPACE INC. 8801 DAVIS AVE. AEROSPACE CT. CHULA VISTA, CA 92011	
06-28-2014	CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES SQUARES ARE 2 PLACE DECIMALS ±0.01 3 PLACE DECIMALS ±0.10 ANGLES ± 1°			
SIZE	CAGE CODE	QWC NO.	REV.
B	074M6	650.630	1
SCALE		MONEY	
		SHEET	11 OF 12

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APICAL INDUSTRIES DBA DART AEROSPACE ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF DART AEROSPACE DBA APICAL INDUSTRIES IS PROHIBITED.



SECTION N-N 11/B4



SECTION O-O

ORIGINAL DATE 04-25-2014		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY N. CAP		DART AEROSPACE APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAVO		SWIVEL FITTING	
CONTRACT NO.		SITE B	REV. G
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±0.10 3 PLACE DECIMALS ±0.005 ANGLES ±.5°		CAGE CODE 07M26	DWG. NO. 650.6300
		SCALE NONE	SHEET 12 OF 12

DART AEROSPACE LTD		Work Order: 144839
Description: Swivel Fitting		Part Number: 650.6316
Inspection Dwg: 650.6300 Rev: C7		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.544	+0.000/-0.01	0.5435	✓		MICOT	OK02
0.432	+0.001/-0.001	0.4315	✓		MICOT+Cal	OK02 OK01
0.323	+/-0.005	0.323	✓		caliper	OK02
1.805	+/-0.002	1.805	✓		HB	310016
1.435	+/-0.005	1.435	✓		Caliper	OK01
1.355	+/-0.005	1.355	✓			
1.36	+/-0.002	1.36	✓			
1.225	+/-0.002	1.225	✓			
1.1375	+/-0.005	1.1375	✓			
1.038	+/-0.005	1.038	✓			
1.000	+/-0.005	1.000	✓			
0.963	+/-0.005	0.963	✓			
0.775	+/-0.002	0.775	✓			
0.690	+/-0.002	0.690	✓			
0.645	+/-0.005	0.645	✓			
0.425	+/-0.005	0.425	✓			
0.375	+/-0.005	0.375	✓			
0.295	+/-0.005	0.295	✓			
0.020	+/-0.005	0.02	✓			
0.700	+/-0.005	0.700	✓			
0.440	+/-0.005	0.440	✓			
0.430	+/-0.005	0.430	✓			
0.750	+/-0.005	0.7493	✓			
0.405	+/-0.005	0.4047	✓			
0.05x45°	+/-0.005	0.047x45°	✓			
0.328	+/-0.005	0.328	✓			
1.175	+/-0.005	1.175	✓			
0.350	+/-0.005	0.350	✓			
3/8-24 mow	MAX. 3988-Min. 3959	0.398	✓		MICOT	OK02
1/2-20 mow	MAX. 5112-Min. 508	0.510	✓		"	"

DAS
45
9.8

Measured by:	Checked by: <i>END</i>	QC Inspector:
Date: 2016-5-4	Date: 16/05/06	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	